

# Work Order ID 55062

January 5, 2010 2:38:28 PM



Page 1

Item ID: D2858-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: 10-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2858	Rev B

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 6.02" Note: 1 Blank Makes 3 Parts

*DTP*  
10/01/10

*mmf*  
10/01/12

4

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2858-1 2-Deburr as per Dwg D2858000

*DTP*

*mmf*  
10/01/12

12 part 3

P10 →

120



QC2- Inspect parts off machine FA1/FA1B

0.00

QC

Memo

0.00

Quality Control

*mmf*  
10/01/12

12 3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2858-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: A Date: 10.01.20  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 10/01/20 Date: 10/01/20

NCR: <u>55062</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/12	140	Qty x3 (parts are done in 3's) Scrap due to the d.400" counter have been too small. (d.395) R.L. First Run operators found out after parts were removed from step up	<u>[Signature]</u> Q3/12	-Scrap + Destroy and replace M <u>110936</u>  - cannot be remachined will be too costly to redo than to be made	<u>mm</u> 10/01/12	<u>mm</u> 10/01/12	<u>[Signature]</u> 10/01/12	<u>S</u> 10/01/12
								<u>S</u> 10/01/12

NOTE: Date & initial all entries

# Work Order ID 55062

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Item ID:	D2858-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	05/01/2010	Start Qty:	12.00		Cust Item ID:	
Required Date:	15/01/2010	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00					12		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M113170 Memo START TIME: 7:30AM 8:00AM FINISH TIME	0.00 0.00							

OK 10/01/12

M 10-01-13

M 10/01/14

(12) (X0)

(X12) 9

OVEN TEMPERATURE: 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55062**

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Page 3

Item ID: D2858-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

BK

10-01-19

12

7



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: 27

0.00



Packaging

Memo

0.00

Packaging

10-1-19 42X SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/19 MF 10-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 2:38:33 PM

Page 1

Work Order ID: 55062



Parent Item: D2858-1



Parent Item Name: Hinge Bracket

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Pure	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	66.3728	2.1259			



6061-T6 Bar 1.50 x 1.25



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

66.3728

107461

11.84

110936

54.5328

2.1259

*[Signature]*  
10/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 55062
<b>Description:</b> Hinge Bracket		<b>Part Number:</b> D2858-1
<b>Inspection Dwg:</b> D2858 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	.174	✓			
Ø0.400	+0.006/-0.001	Ø .400				
R0.125	+/-0.010	R .125	✓			
0.328	+/-0.010	.328	✓			
0.820	+/-0.005	.818	✓			
1.476	+/-0.010	1.476	✓			
0.342	+/-0.010	.341	✓			
0.875	+/-0.005	.875	✓			
1.56	+/-0.030	1.57	✓			
0.147	+/-0.010	.142	✓			
0.717	+/-0.010	.717	✓			
0.697	+/-0.010	.697	✓			
0.229	+/-0.010	.230	✓			
R0.125	+/-0.010	R .125	✓			
R0.063	+/-0.010	R .063	✓			
0.063	+/-0.010	.064	✓			
0.126	+/-0.010	.123	✓			
0.630	+/-0.010	.628	✓			
R0.354	+/-0.010	.359	✓			
0.965	+/-0.010	.964	✓			
Ø0.166	+0.005/-0.001	Ø .163	✓			
R0.125	+/-0.010	R .125	✓			
32.7°	+/-0.5°	32.7°	✓			

<b>Measured by:</b> MMF	<b>Audited by:</b> GNF	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/6/12	<b>Date:</b> 10/10/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by:	Approved
A	07.10.30	New Issue	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

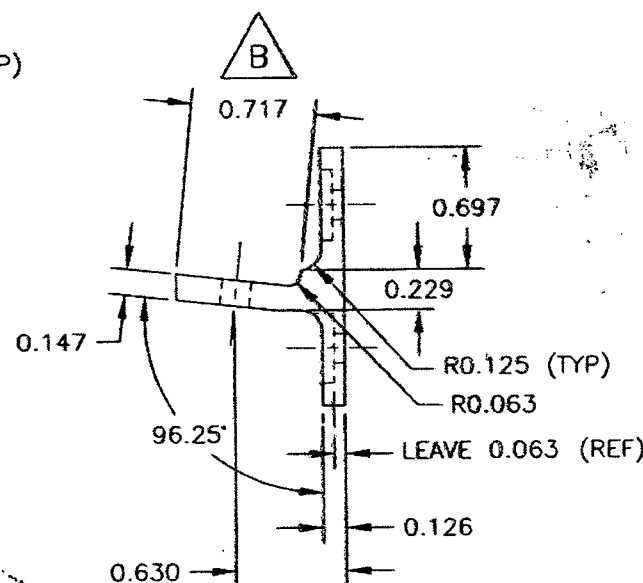
**NOTE:** Date & initial all entries

**DART**

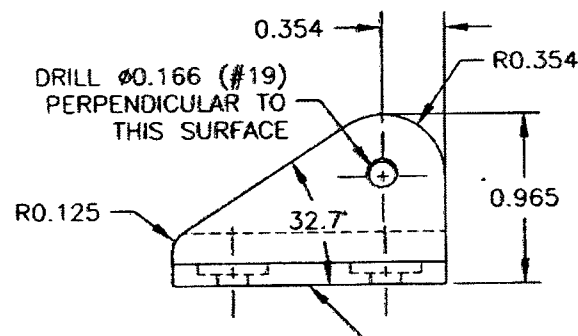
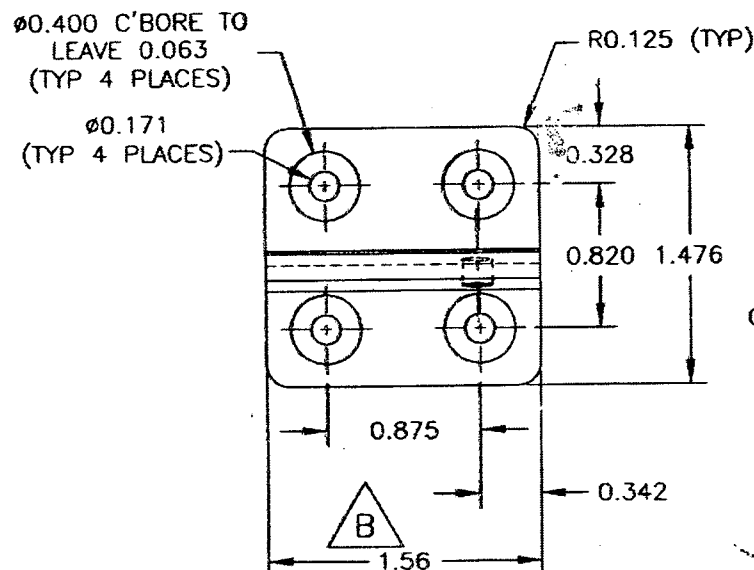


RELEASED  
94.03.08 KE

DESIGN	LE	DRAWN BY	KE	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	UP	APPROVED	KE	DRAWING NO.	D2858
DATE	99.02.28	TITLE	HINGE BRACKET	SHEET 1 OF 1	REV. B
A	98.12.14	NEW ISSUE			
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559			



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55642  
B/10-1-05



ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN  
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries